

Date: Friday, 11/04/2008 11:11:38 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	38528		
Estimate Number :	12902		
P.O. Number :		Part Number :	D350813
This Issue :	11/04/2008	Drawing Number :	D3508 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11/04/2008	Drawing Revision :	C
Previous Run :	36416	Material :	
Written By :		Due Date :	30/04/2008
Checked & Approved By :	JLD 08.4.11	Qty:	12 Um: Each
Comment :	Est Rev:A New Issue 07.06.12 EC Est Rev:B Rev C dwg 07-12-06 DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S20GA

304/316 .040 Sheet



Comment: Qty.: 0.1806 sf(s)/Unit Total : 2.1672 sf(s)

304 SS .038" THK

(M304S20GA)

Batch:

107744

IB 8-4-16

MAT NOT PULLED

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3508

Dwg Rev: C

Prog Rev: C

IB 8-4-16

2-Deburr if necessary

IB 8-4-16

(12)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-4-16

(12)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



IB 8-4-16

(12)

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

IB 08/04/21

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 11:11:38 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38528

Part Number: D350813

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/21 X12

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld hardcoat as per dwg D3508 QSI004

Hardcoat 2059b Batch:

M105959

08-05-27

12x

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/05/27 X12

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/27

30m'n

27/05/2008

S.279 12.17

#1 3/9.5 F

#2 B3PS28 F

#3

#4 D350813 F

10.0

POWDER COATING

POWDER COATING



M105642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M. 08/05/27

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08.05.27

X12

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-21

08-05-27

X12

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38528
Description: Wearplate		Part Number: D3508-13
Inspection Dwg: D3508	Rev: C	Page 1 of 1

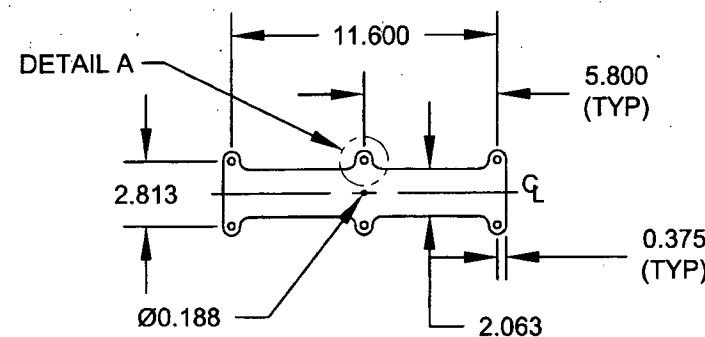
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

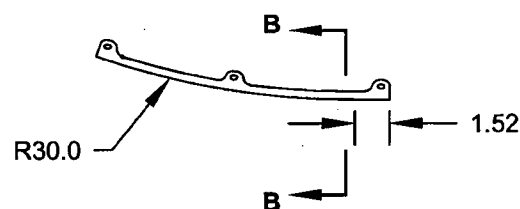
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.38	+/-0.030	8.38	*			
5.625	+/-0.010	5.625	*			
0.375	+/-0.010	.375	*			
2.813	+/-0.010	2.813	*			
2.063	+/-0.010	2.069	*			
Ø0.187	+0.005/-0.001	.191	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.302	*			

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-4-16	Date: 08-04-16	Date:	N/A

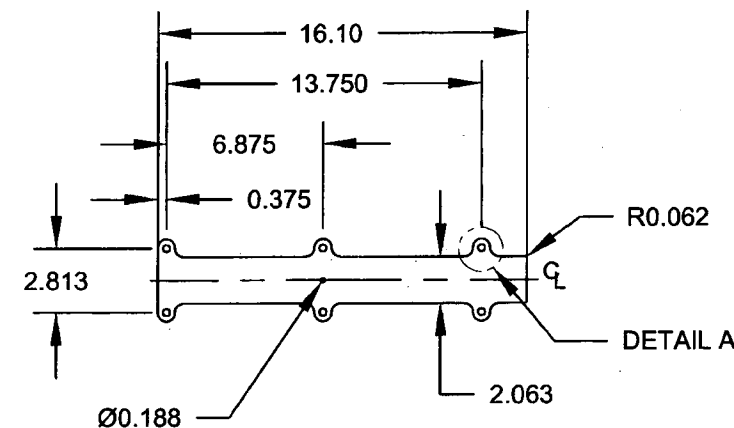
Rev	Date	Change	Revised by	Approved
A	08.01.23	New Issue	KJ/EC/DD	[Signature]



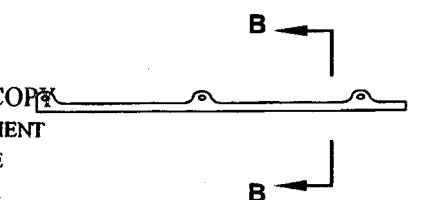
D3508-1 FLAT PATTERN



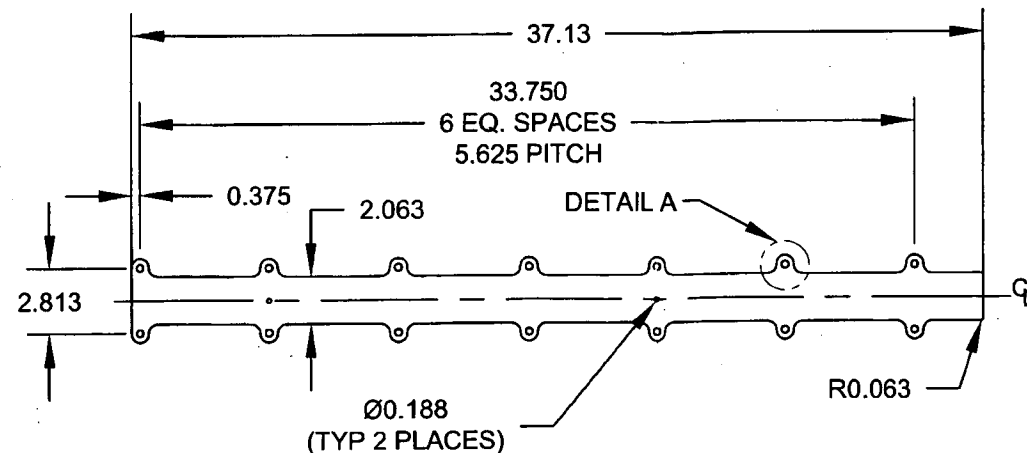
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



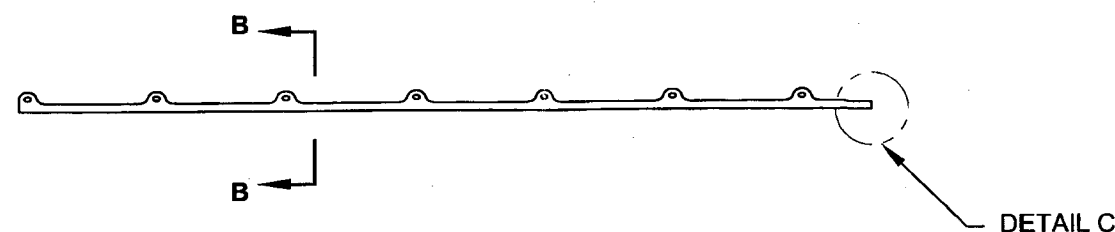
D3508-7F FLAT PATTERN



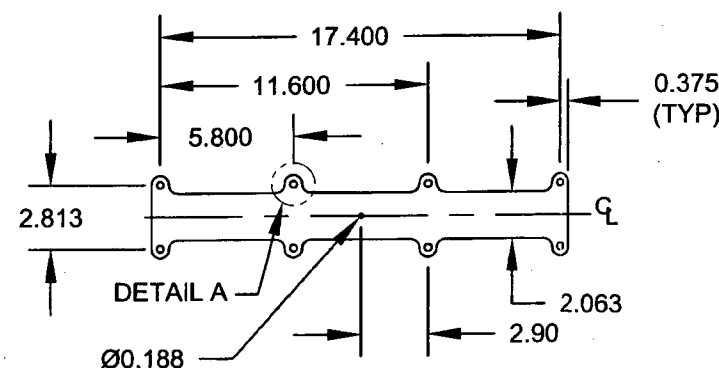
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



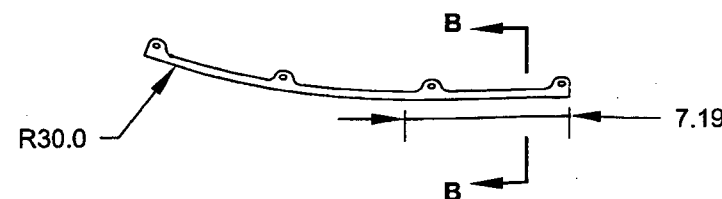
D3508-3 FLAT PATTERN



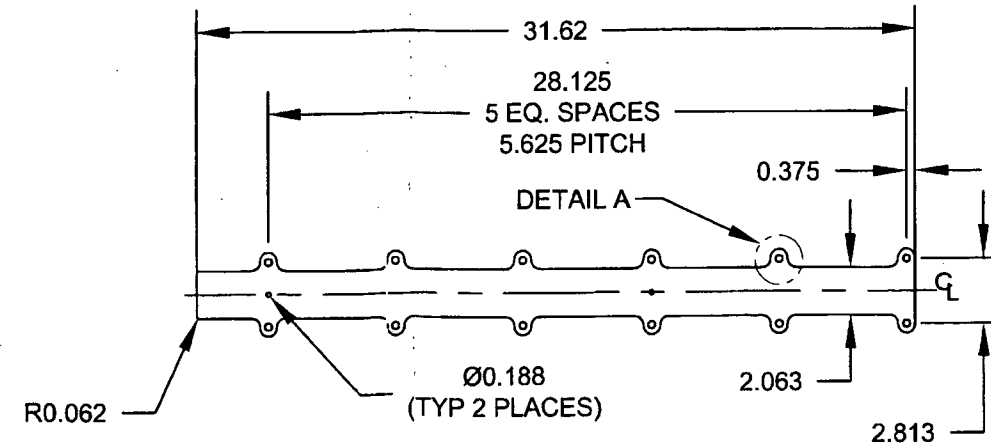
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



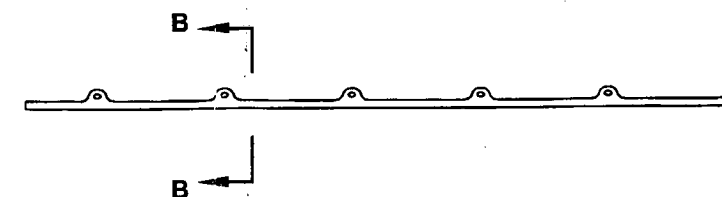
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

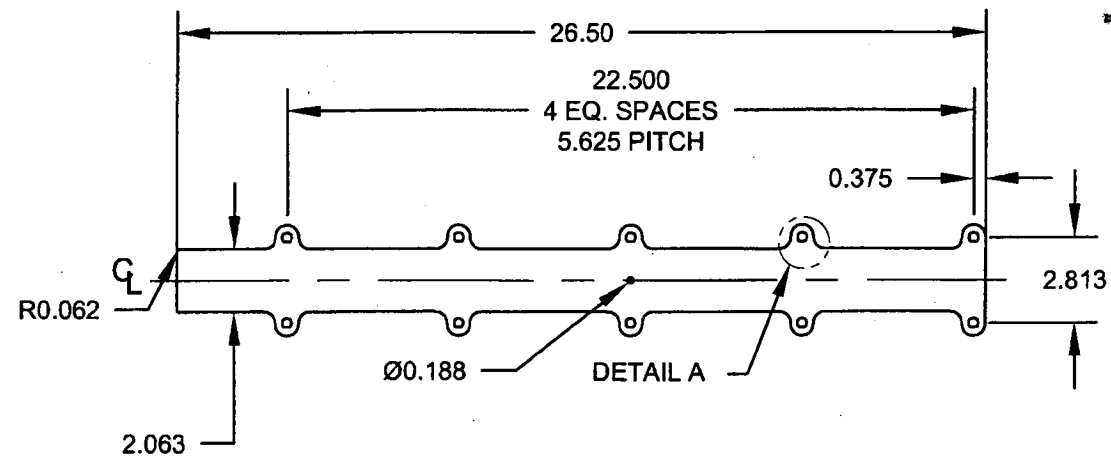
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

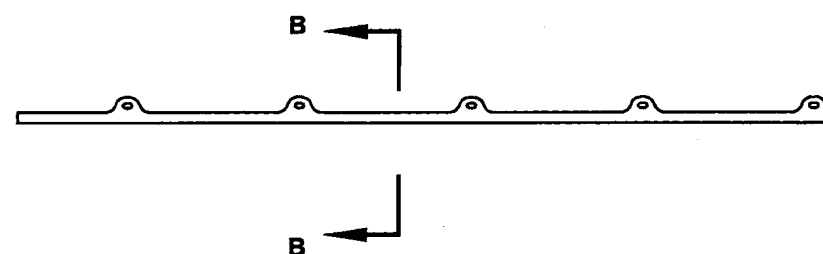
RELEASED
07-11-16

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WITHOUT NOTICE
WORK ORDER
NO. 38528

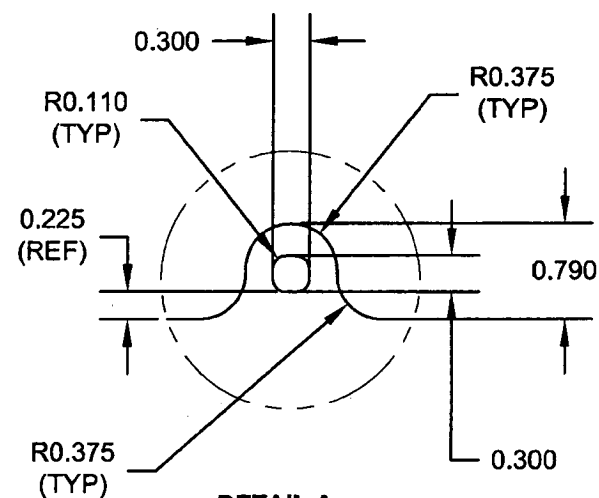
C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	24	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	24		
CHECKED	13	DRAWING NO.	REV. C
MFG. APPR.	13	D3508	SHEET 1 OF 2
APPROVED	13	TITLE	SCALE
DE APPR.	13	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



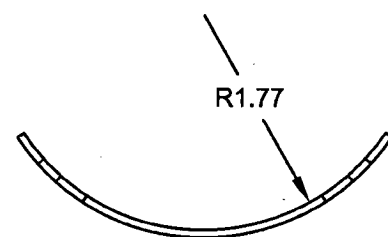
D3508-11F FLAT PATTERN



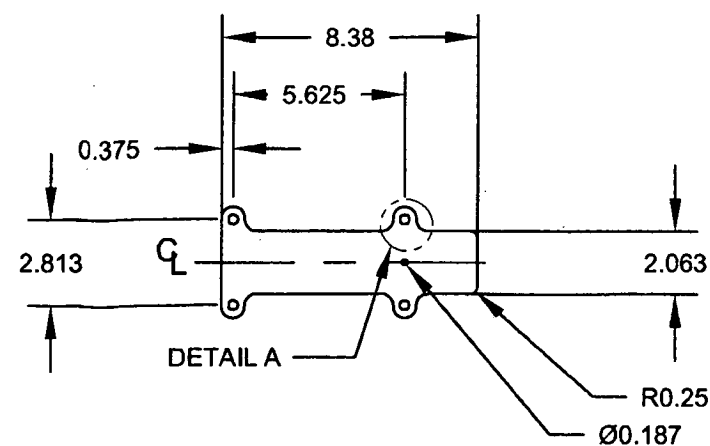
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



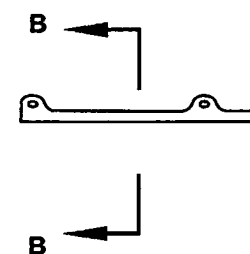
DETAIL A
(SCALE 2:3)



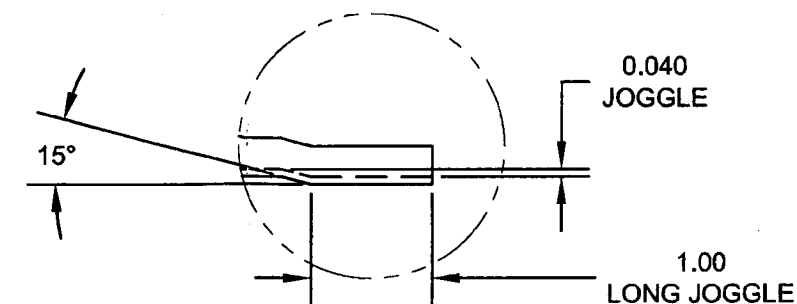
SECTION B-B
(SCALE 2:3)



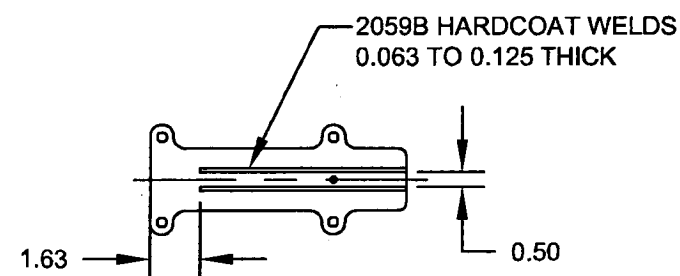
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	E	D3508	SHEET 2 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.		WEARPLATE	1:6
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